



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9711

Job Sheet 212486



Part No: 646.9711

Job Qty: 50 pcs

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/25/20

Job Tracking No:

Due Date: 9/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.9700 REV.J IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD IPP REV:B 2020.05.27 AS PER
DWG REV.J DD VERF:JFS

Ship Via:

Bill of Materials

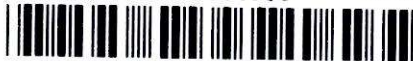
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	50 pcs		8/21/20	0.00	1.56	Bandsaw - 1		St 20-09-21
110	HAAS 5 Axis	50 pcs		8/24/20	0.50	20.00	HAAS - 1 - 5 - B4B HAAS - 2 - 5 - B4B		St 20-09-21
120	QC 2	50 pcs		8/24/20	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62 QC 2 - 63 QC 2 - 8		St 20-09-21



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S301760



Part: 646.9711

Job No: 212486

Serial No/Batch: S301760

Revision: Rev.J

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/21/20

Plex 8/25/20 9:13 AM Dart.lajeunesse.marie

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	50 pcs	8/24/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Outsource - 1 - Heat Treat	50 pcs	9/12/20		MEI001-VC 15
150	Packaging 2-1 - Receive - B4B	50 pcs	9/12/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 -

20/09/22

22 SEP 2020

SEP 29 2020

				B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155	QC 6	50 pcs	9/12/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
160	Spray Paint - 2 - B4B	50 pcs	9/14/20	0.00 1.67	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
170	QC 14	50 pcs	9/14/20	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					Plex 8/25/20 9:13 AM Dart.lajeunesse.marie

DAS
SEP 3 4 2020 40
9-89

DAS
41 OCT 0 4 2020
9-89

					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	DAS
					QC 14 - 40	OCT 05 2020 40
					QC 14 - 19	9-89
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
					QC 14 - 82	
					QC 14 - 87	
					QC 14 - 47	
185	Packaging 3-1 - Stock - B4B	50 pcs	9/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	OCT 06 2020
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
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				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	50 pcs	9/14/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-02
				QC 21 - SA - 77	OCT 06 2020

Part Op 100 - (Bandsaw) Cut Blank at 4.625"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB135 FOLIO REV-AB

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

160 - (Spray Paint / NDT Room) ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #4 5265778

170 - (QC14- Inspect Spray Paint)

185 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	19.3000 ft (.386 ea)	100-Bandsaw - 1	5257174 X28 5299116 X22

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	19	23	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.340Inches + 0.000 - 0.005	0.340 0.335		
2	Blade	0.177Inches + 0.005 - 0.001	0.182 0.176		
3	Blade	3.200Inches ± 0.005	3.205 3.195		
4	Blade	0.600Inches ± 0.005	0.605 0.595		
5	Blade	0.985Inches ± 0.005	0.990 0.980		
6	Blade	2.400Inches ± 0.005	2.405 2.395		
7	Blade	1.200Inches ± 0.005	1.205 1.195		
8	Blade	0.250Inches ± 0.005	0.255 0.245		
9	Blade	37.2Angle ± 0.5	37.7 36.7		
10	Blade	0.290Inches ± 0.010	0.300 0.280		
11	Blade	30.0Angle ± 0.5	30.5 29.5		

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DART AEROSPACE LTD		Work Order:	212486
Description: Blade		Part Number:	646.9711
Inspection Dwg: 646.9700	Rev: D2		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	DAS 33	Checked by:	mf	QC Inspector:	
Date:	9-89 20/09/17	Date:	20/09/17	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	13.06.03	New Issue	KJ	
B	13.06.27	Dwg Rev updated	KJ	
C	13.07.18	Dwg Rev updated	KJ	
D	13.08.23	Dimensions revised	KJ	
E	13.11.26	Dwg Rev updated	KJ	
F	16.05.27	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB047152



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047152

PO Date: 9/22/20

Due Date: 9/25/20

Purchase Order

Revision:

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	212486	646.9711	646.9700 Rev.J	Blade : Various STC's (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed X50	-	9/25/20	50 pcs	0 pcs	50 pcs	\$5.60/pcs	\$280.00
												DAS 40 9-89
2	211829-A	C10-23K	C10-23K REV.B	Stationary Keeper (Outsource process - Heat Treat) 1-Issue P/O; P/O RC 40-44 Material; 4140 2-Bead blast 3-Apply LPS-3 to ALL steel parts 4-Certificate of Conformity is required	Firmed X3	-	9/25/20	3 pcs	0 pcs	3 pcs	\$91.97/pcs	\$275.91
												SEP 29 2020 SEP 29 2020
Grand Total:												\$555.91



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047152



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in-detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

A handwritten signature in dark ink, appearing to be "Patrick Lussier", written over the signature line.

Plex 9/28/20 1:07 PM dart.lussier.patrick

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
347204	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
POHB047152	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

HARDNESS

58 - 62 HRC

5

59 - 60 HRC

(907)

DA
40
B-er

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
50	15	646.9711 (50) 646.9711 JOB 212486 1 BOITE DE CARTON

2/10/20

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

[Signature]



DATE: 2020-09-26

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
347204	1	148254

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
POHB047152		A2	2020/9/22	CLIENT
QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

50 646.9711

(50) 646.9711 JOB 212486

15,

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EXPÉDIÉ PAR:
Shipped by:

QUANTITÉ EXPÉDIÉE / Quantity Shipped :

50 ✓

POIDS EXPÉDIÉ / Weight Shipped :

15,00

QUANTITÉ RESTANTE / Quantity Remaining :

0

POIDS RESTANT / Weight Remaining :

0,00

RECEIVED

SEP 28 2020

DART AEROSPACE LTD.

APPROUVÉ
[Signature]

QUANTITÉ EXPÉDIÉE / Quantity Shipped:

50

POIDS EXPÉDIÉ / Weight Shipped :

15,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2020/09/28